






Work Order ID 71364

Wednesday, June 29, 2011 3:00:56 PM



Page 1

Item ID: D2221 Accept  Setup Start 
Revision ID:
Item Name: 350 Basket Base Stop 
Start Date: 6/29/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 7/7/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan:  Date: 11-06-29 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100		0.00							
-----	--	------	--	--	--	--	--	--	--

	Large Fab								
--	-----------	--	--	--	--	--	--	--	--

Large Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221								
-----------	--	--	--	--	--	--	--	--	--

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M115728


PLEASE NOTE

IF MAKING -041A OR -043A :

DRILL HOLES FOR GAS SPRING

IN D3825-041 AS PER

DSI 9473


 11.07.14

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
-----	--	------	--	--	--	--	--	--	--

									
--	--	--	--	--	--	--	--	--	--

QC	Memo	0.00							
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Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

 11.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 6/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

Substuf

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-7-14

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Page 3

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Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

M117745.

Memo

0.00

1

11-7-15.

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 8:20

OVEN TEMPERATURE: 1100°

FINISH TIME: 8:50

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

1 of 11-7-15

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

ES 11/07/15 ①

CK 11/07/15
MF
11-07-15

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Picklist Print

Wednesday, June 29, 2011 3:01:02 PM

Page 1

Work Order ID: 71364

Parent Item: D2221

Parent Item Name: 350 Basket Base





Start Date: 6/29/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	8.0000	1	1		11.07.12	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>5</div> <div></div> </div> <div> <div>69261</div> <div>5</div> <div></div> </div> <div> <div>WA006</div> <div>3</div> <div></div> </div> <div> <div>67465</div> <div>3</div> <div></div> </div>													
D2221-5  Rib		Manufactured	No			100	Each	8.0000	2	2		11.07.12	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA006</div> <div>8</div> <div></div> </div> <div> <div>67117</div> <div>2</div> <div></div> </div> <div> <div>69257</div> <div>6</div> <div></div> </div>													
D2221-7  Rib		Manufactured	No			100	Each	7.0000	1	1		11.07.12	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>7</div> <div></div> </div> <div> <div>70130</div> <div>3</div> <div></div> </div> <div> <div>71219</div> <div>4</div> <div></div> </div>													
D2232-3  Basket Hinge		Manufactured	No			100	Each	0.0000	2	2		11.07.14	

B 71796

2

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 71364

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 6/29/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2235-1 Manufactured No

100 Each

14.0000

2

2



Basket Rib

Location

Loc Qty

Loc Code

WA

10

70669

10

WA005

4

66895

4

D2581 Manufactured No

100 Each

89.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

89

69258

28

69739

10

70766

51

D3442-1 Manufactured No

100 Each

18.0000

2

2



Shim

Location

Loc Qty

Loc Code

WA

17

71224

17

WA005

1

65783

1

D3825-041 Manufactured No

100 Each

2.0000

2

2



Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

2

70426

2

70843

Wednesday, June 29, 2011 3:01:03 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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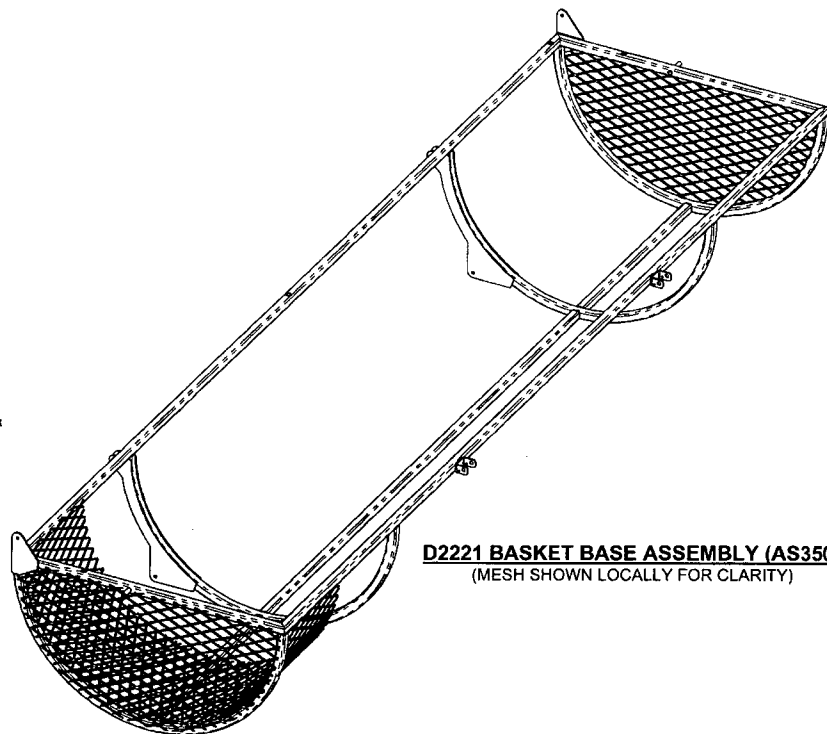
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71364

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: 42.00 lbs APPROX
 - 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2221-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	NSS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

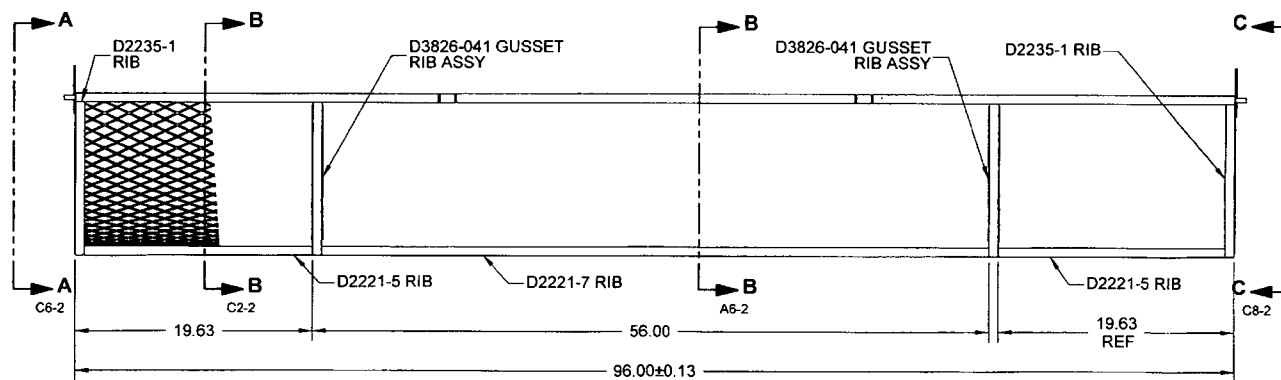
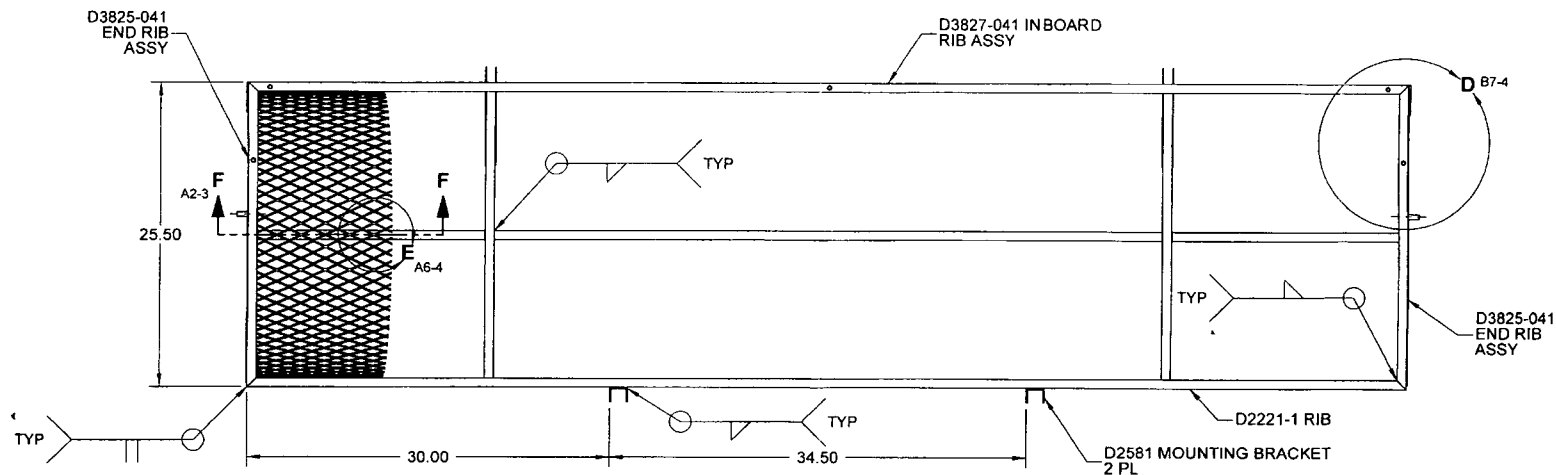
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

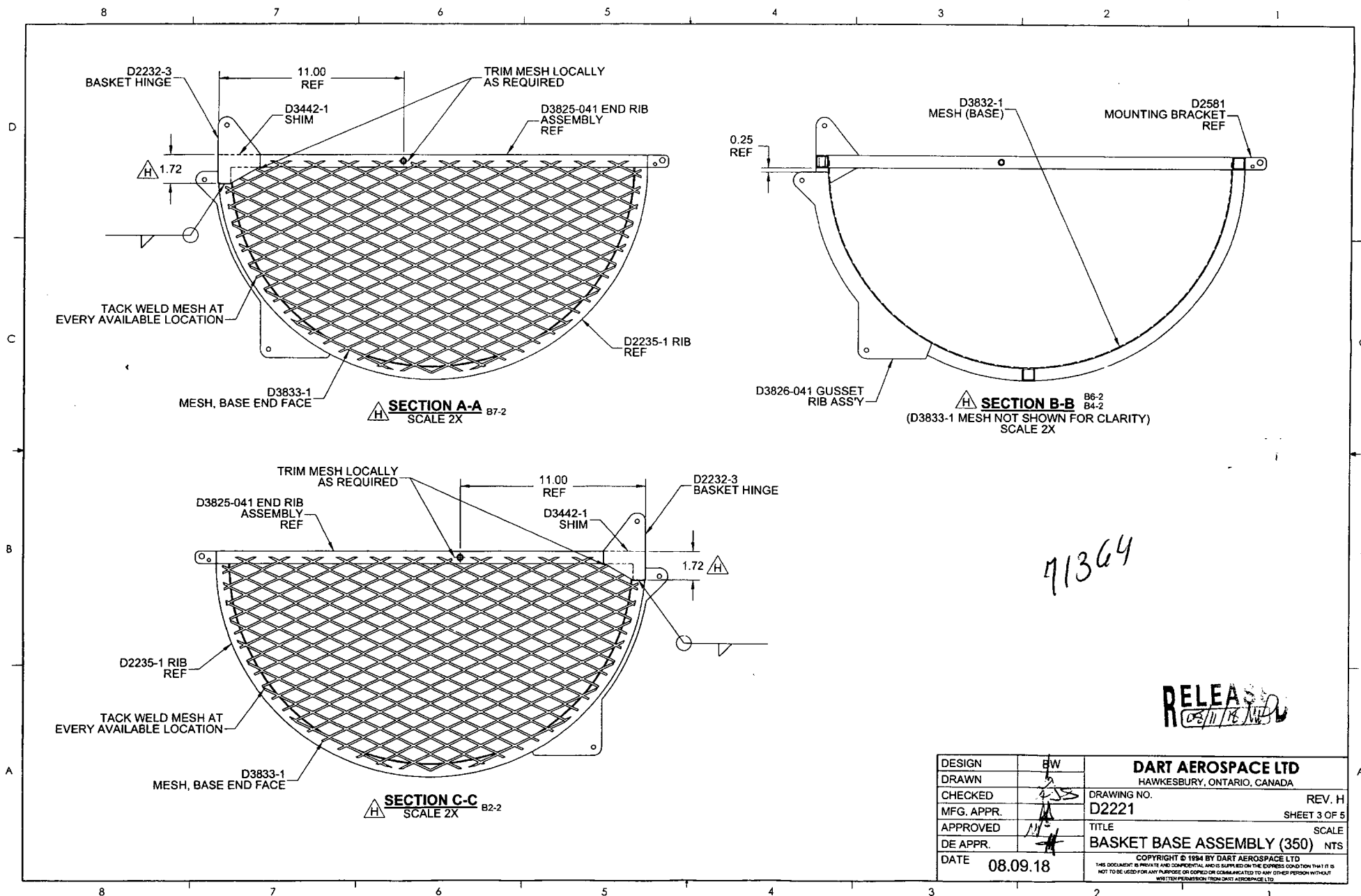
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71364

RELEASED
03/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4-SS	DRAWING NO. D2221	REV. H
MFG. APPR.	11		SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	11	BASKET BASE ASSEMBLY (350)	NTS
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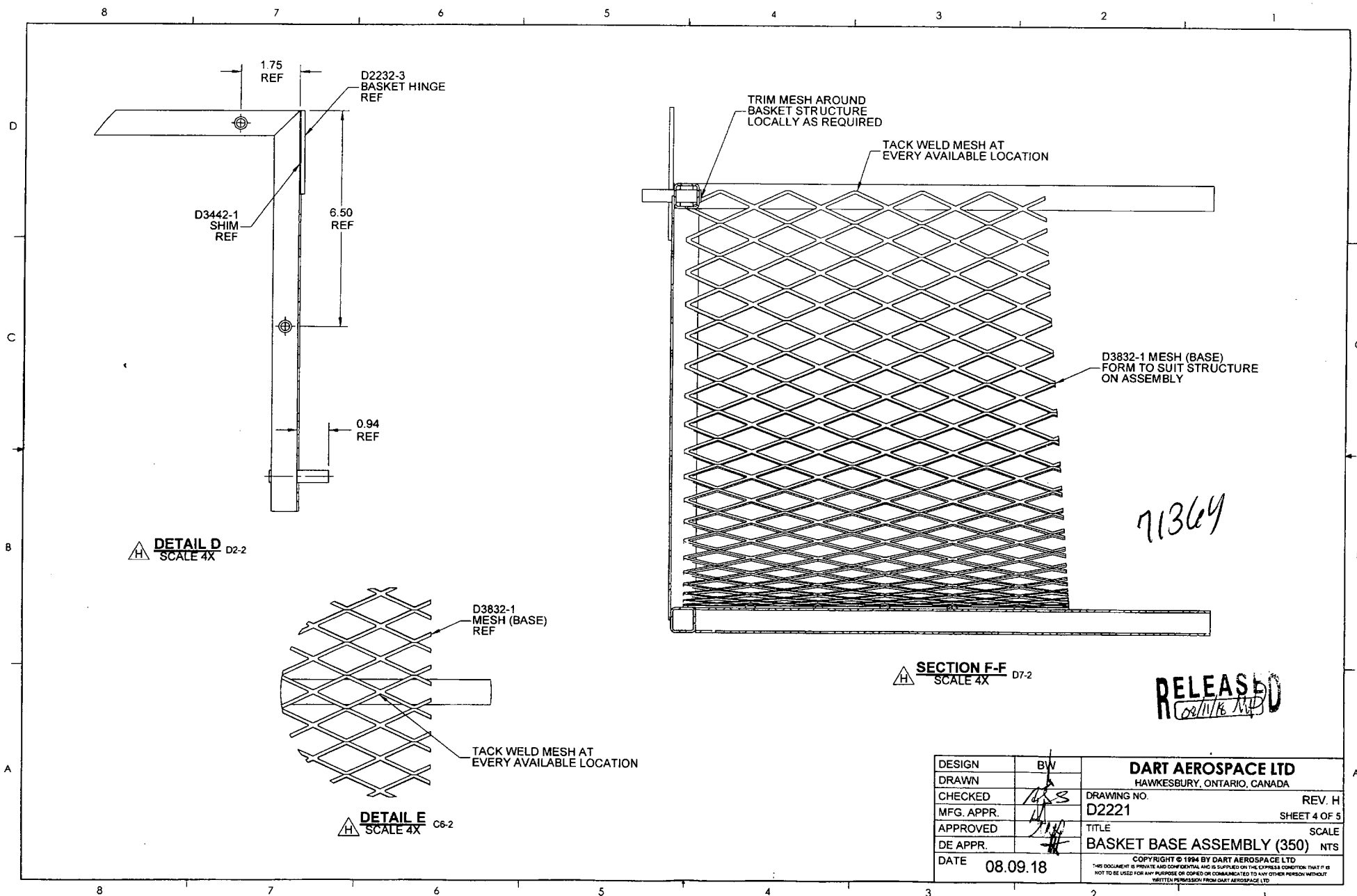
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DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	16/3	DRAWING NO.	REV. H
MFG. APPR.	14/4	D2221	SHEET 4 OF 5
APPROVED	14/4	TITLE	SCALE
DE APPR.	14/4	BASKET BASE ASSEMBLY (350)	NTS
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Dart Aerospace Ltd

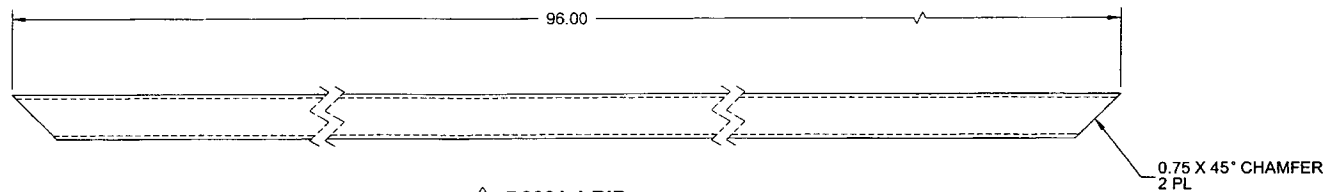
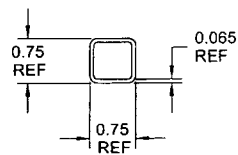
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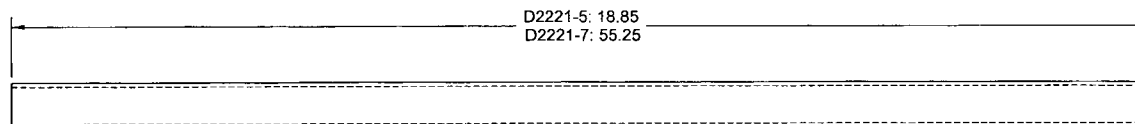
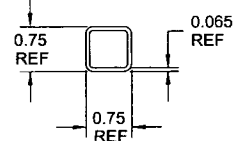
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D2221-1 RIB



D2221-5/-7 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
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RELEASED
08/11/18

71364

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